

Work Order ID 77189

November-28-11 9:21:41 AM

ship Dec 5th

77189

Page 1

Item ID: D4092-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step

Start Date: 11/28/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/28/11 Req'd Qty: 4.00

4

Customer:

Reference: rework to current rev

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4092

B

130

QC8 - inspect parts - second check

0.00

130

QC

Quality Control

Memo

PULL FROM ENG SHELF:
4 X D4092-1 B62564
RE-INSPECT TO REV.B

0.00

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Hand Finishing

Memo

STRIP PAINT
RE-ALODINE
RE-WINGWALK
PER.DRWG D4092 REV.B

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

For 11-11-28

4 B 11-12-5
4 B 11-12-6

4 x 60 11/12/06

Work Order ID 77189

November-28-11 9:21:41 AM

77189

Page 2

Item ID: D4092-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step

Start Date: 11/28/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/28/11 Req'd Qty: 4.00

4

Customer:

Reference: rework to current rev

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: 24/A

0.00

170

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

PCU/1/4/6 (4)

11/12/16

MF 11-12-06

subline tool 2

Picklist Print

November-28-11 9:21:40 AM

Page 1

Work Order ID: 77189

Parent Item: D4092-1

Start Date: 11/28/11

Required Date: 11/28/11

Parent Item Name: Maintenance Step

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No				Each	1.0000		4			
Maintenance Step													

Location

Loc Qty

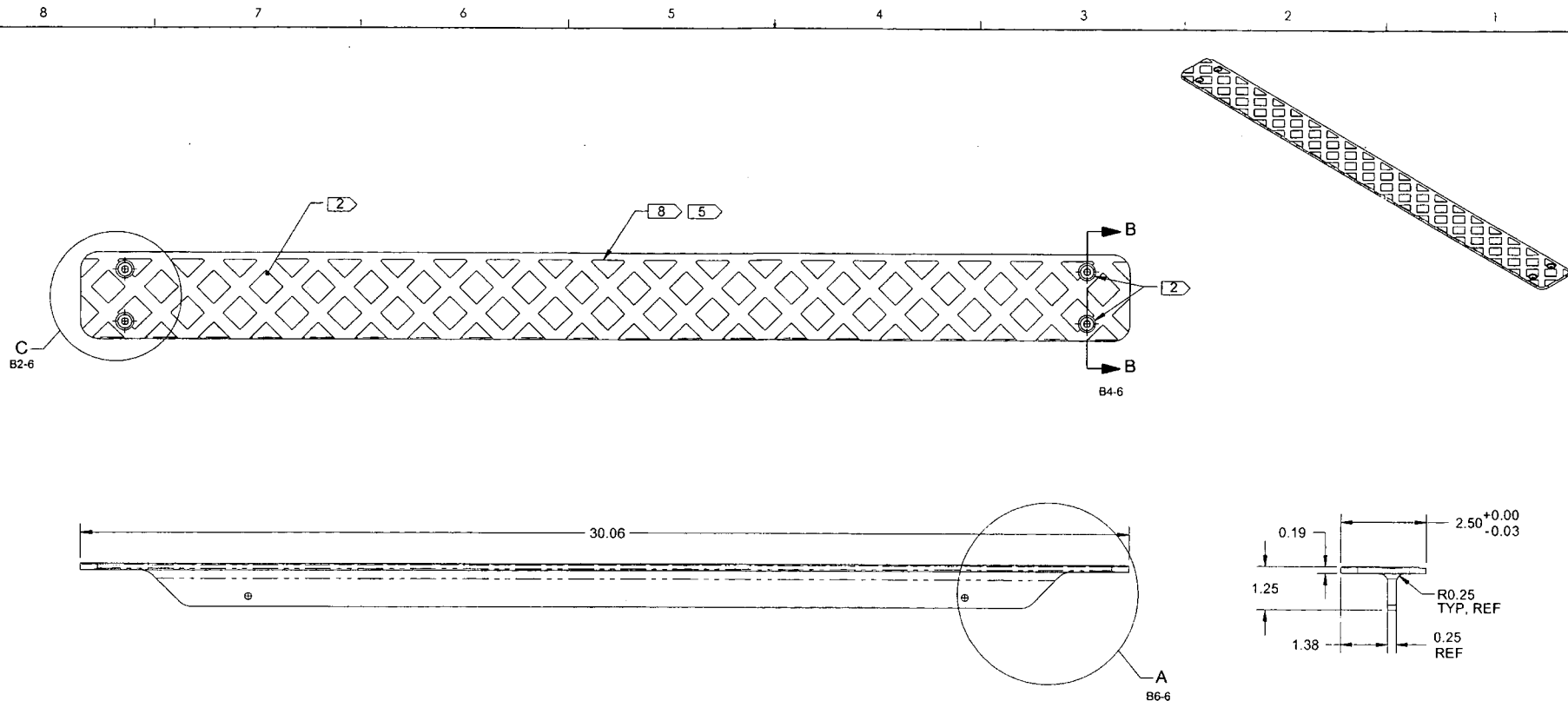
Loc Code

GA

1

74303

1



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

RELEASED
2011-09-22
JWW

NOTES:

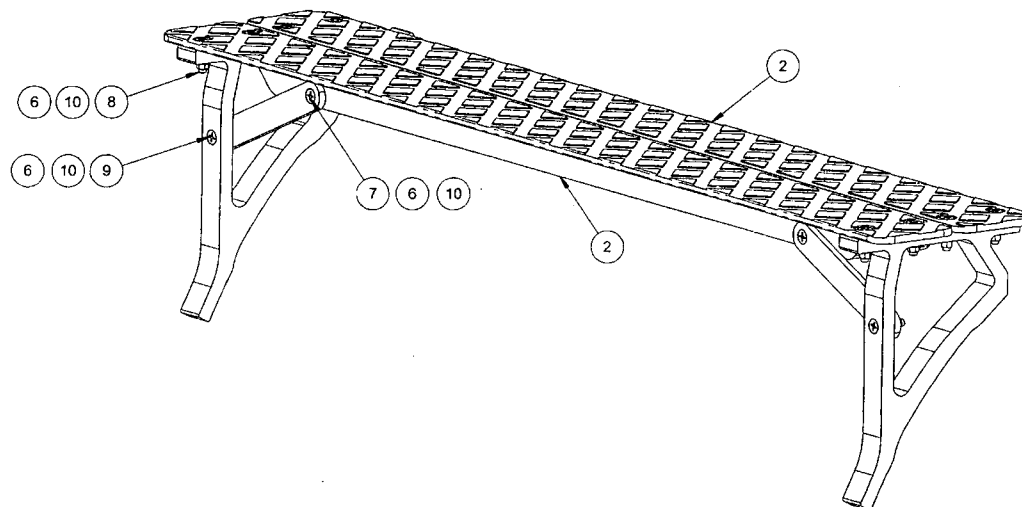
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 5 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASSY	NTS
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RELEASED
2011-09-22

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MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASSY	NTS
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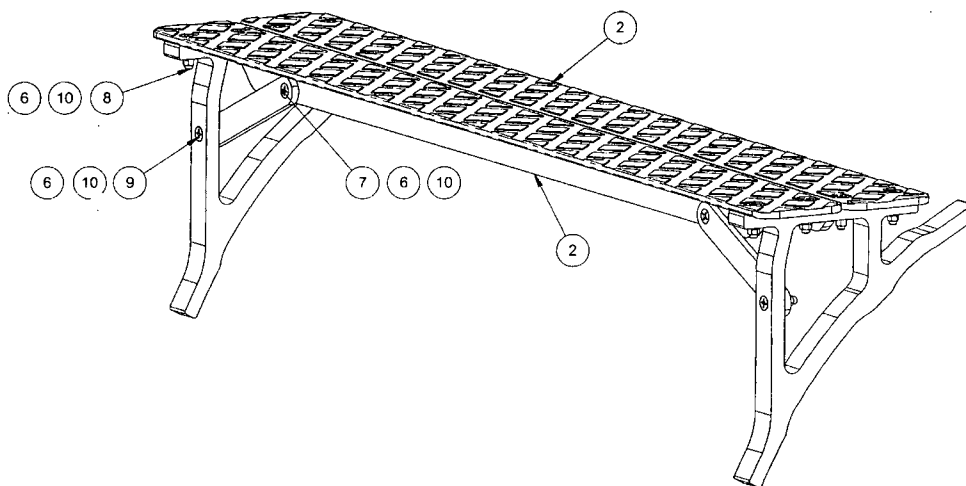
D4092-041 MAINTENANCE STEP ASSEMBLY



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 1 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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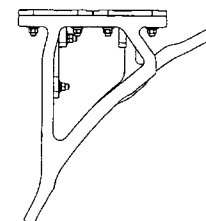
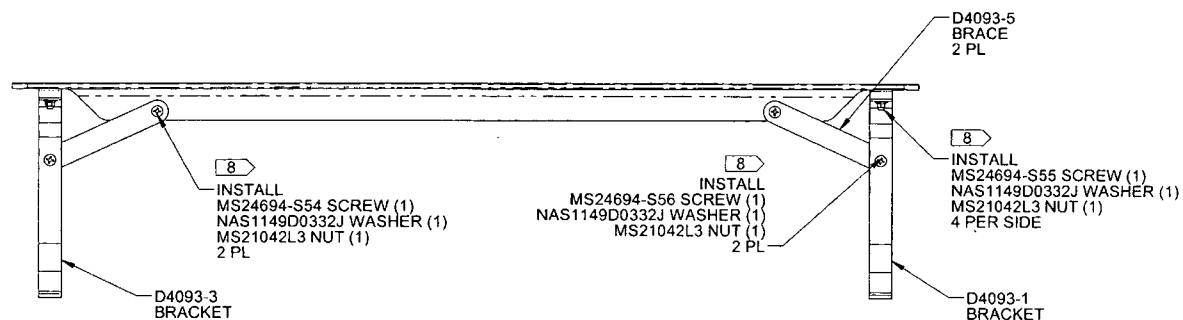
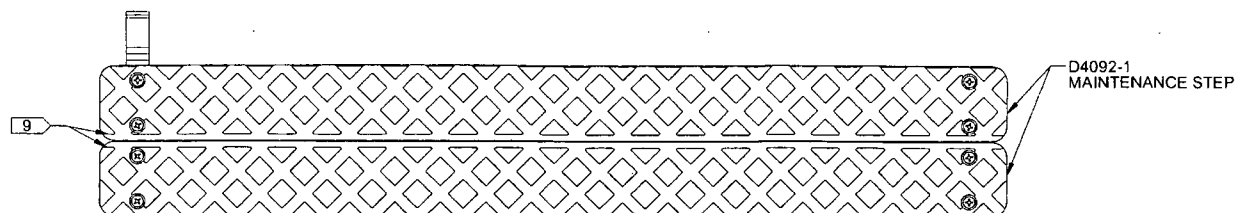
D4092-042 MAINTENANCE STEP ASSEMBLY



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>160</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>91</i>	D4092	SHEET 2 OF 6
APPROVED	<i>160</i>	TITLE	SCALE
DE APPR.	<i>160</i>	MAINTENANCE STEP ASSY	NTS
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RELEASED
2011-09-22
JM



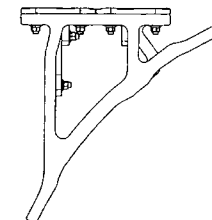
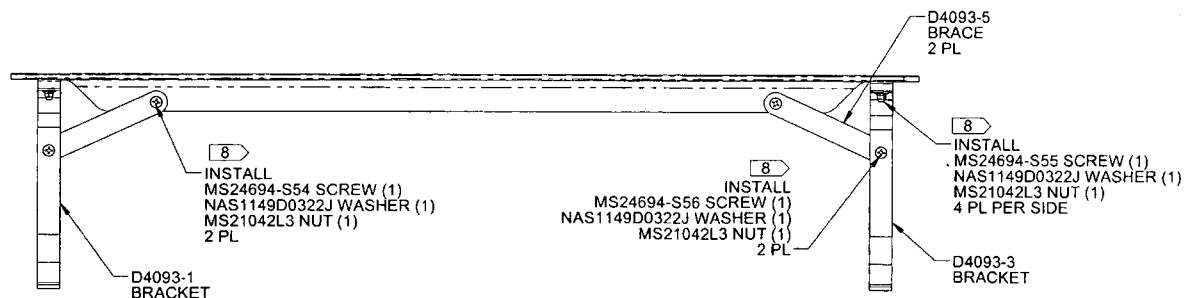
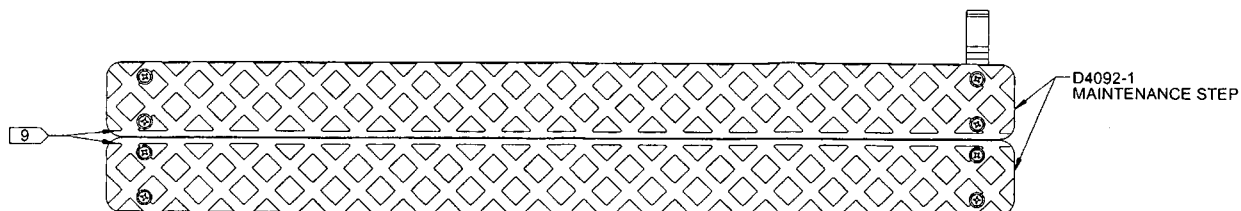
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 3 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	MAINTENANCE STEP ASSY	NTS
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RELEASED
2011-09-22



D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 4 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASSY	NTS
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PRELIMINARY ISSUE

Work Order ID 63047

Tuesday, October 19, 2010 9:12:09 AM

Page 1

Item ID: D4092-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Maintenance Step

Start Date: 10/19/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-10 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	2 PBI-02

100 Cut blanks as per folio

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

B.A 10/11/01

4 0

110

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA935

Dwg Rev:

Folio rev:

Deburr

SA 10/11/01


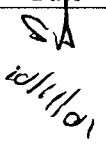
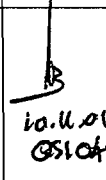
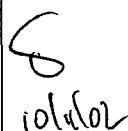
4 1

150

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4092-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HA Date: 10.11.08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>63047</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/01	(10)	1 part machined too deep Part not sitting in vice properly R.C. Lack of attention	 G. H. O. 1 01 Oct	Scrap - destroy - replace Qty 1 Batch: 8323	 SA 10/11/01	B.A. 10/11/01	 G. H. O. 1 01 Oct	 S 10/11/01

NOTE: Date & initial all entries

Work Order ID 63047

Tuesday, October 19, 2010 9:12:09 AM



Page 2

Item ID: D4092-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Maintenance Step

Start Date: 10/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/26/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

SA 10/11/01

0.00

4

1

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

10-11-15
per printing
per PSI

0.00

SA 10/11/01

4

0

Inspected as per Rev B (see attached)

11-11-25

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

7/2/10 10/11/02

4

0

Work Order ID 63047

Tuesday, October 19, 2010 9:12:09 AM

Page 4

Item ID: D4092-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Maintenance Step

Start Date: 10/19/2010 Start Qty: 4.00

Required Date: 10/26/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: *6-A*

0.00



Packaging

Memo

B62562 (2)
B62803 (2)

0.00

Packaging

EP 10/11/03 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/03
*10.11.16**Re-inspects to Rev B*
Day 8/11/25

POSITIVE RECALL

EFFECTIVE *10-11-02* *AUT*

RELEASED _____ DATE _____

MF
10-11-3

Picklist Print

Tuesday, October 19, 2010 9:12:14 AM

Page 1

Work Order ID: 63047

Parent Item: D4092-1

Parent Item Name: Maintenance Step



Start Date: 10/19/2010

Required Date: 10/26/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108 		Manufactured	No			100	f	221.5800	0.333333333	1.403509			
													

Extrusion (HPK)

Location

Loc Qty

Loc Code

MAT07

221.58

8323

221.58

10.1000 ^{FX} B.A 10/11/01
2-5 At sk 10/11/01

DART AEROSPACE LTD		Work Order: 63047
Description: Maintenance Stop		Part Number: 14092-1
Inspection Dwg: 14092 Rev: A PBI		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

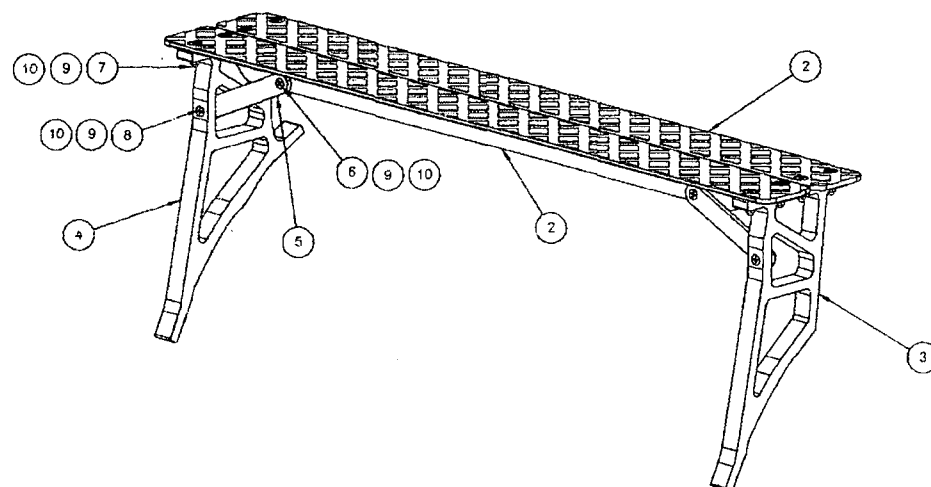
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.06	± 0.030	30.06	/		Tape	OK-1
250	± 0.030	2.499	/		Verin	OK-G
25 ref	± 0.030	25	/			
1.38	± 0.030	1.372	/			
1.25	± 0.030	1.245	/			
.19	± 0.030	.186	/			
R.50	± 0.030	R.50	/			
.20	± 0.030	.201	/			
.030 id	± 0.010	.033	/			
1.500	± 0.010	1.500	/			
.50	± 0.030	.50	/			
1.25	± 0.030	1.25	/			
.69	± 0.030	.686	/			
Ø.201	± 0.006	Ø.202	/			
Ø.50	± 0.030	Ø.50	/			
Ø.370x100°	± 0.010	Ø.370x100°	/			
.30	± 0.030	.302	/			

Measured by: SA	Audited by: H.A	Preliminary Approval: -
Date: 10/11/01	Date: 10/11/0	Date: -

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT



D4092-041 MAINTENANCE STEP ASS'Y

PRELIMINARY ISSUE

~~10~~ 10.10.04

PB1	ADD DIMENSIONS (ZN B8-6 & B5-6)	RF	10.10.04
A	NEW ISSUE	RF	10.08.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	10.10.04		

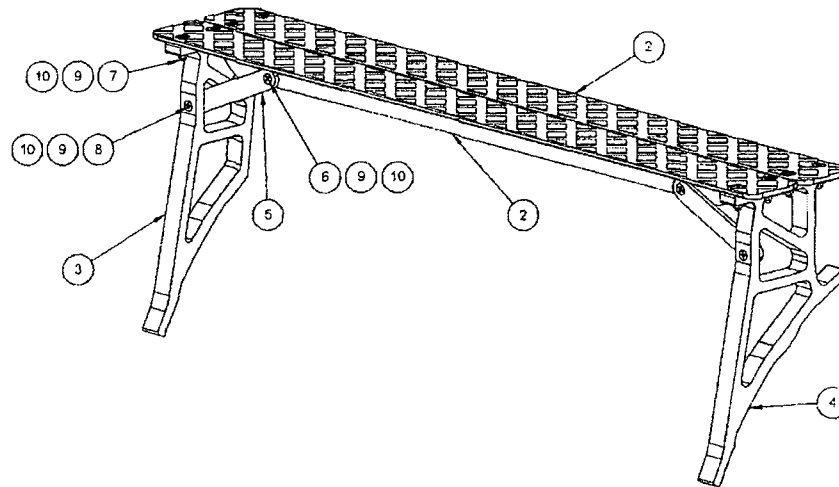
DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D4092** REV. PB1
SHEET 1 OF 6

TITLE **MAINTENANCE STEP ASSY** SCALE **NTS**

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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT



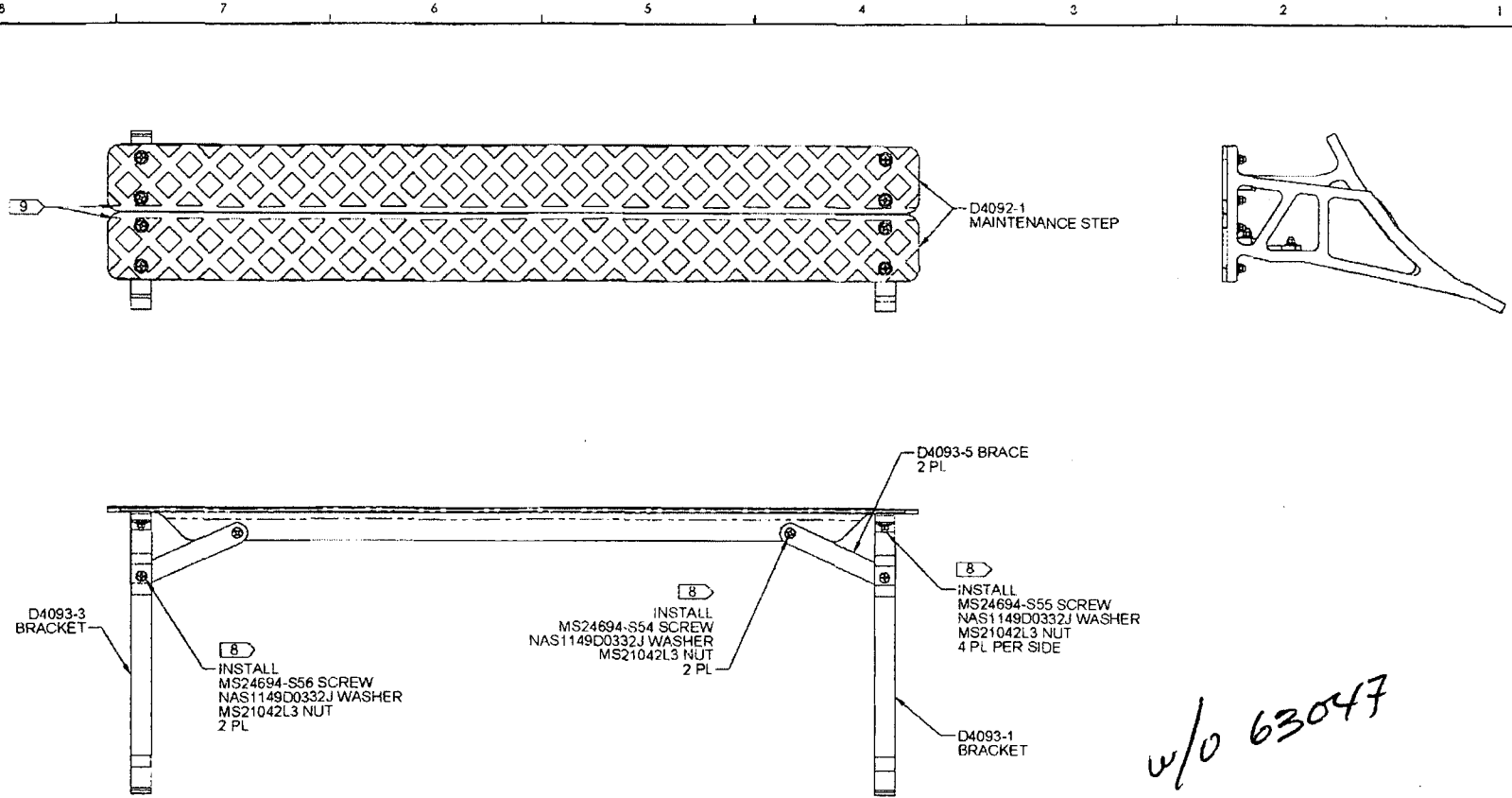
D4092-042 MAINTENANCE STEP ASS'Y

PRELIMINARY ISSUE

RF 10.10.04

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG APPR		D4092	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR		MAINTENANCE STEP ASS'Y	NTS
DATE	10.10.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	

w/o 63047



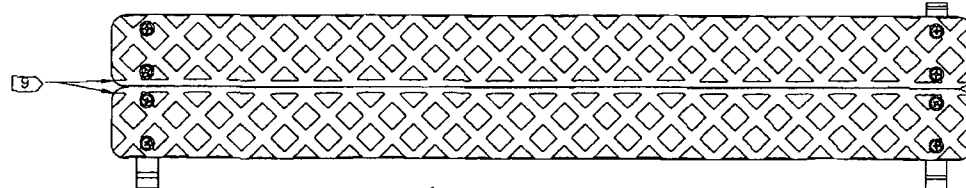
D4092-041 MAINTENANCE STEP ASS'Y

PRELIMINARY ISSUE

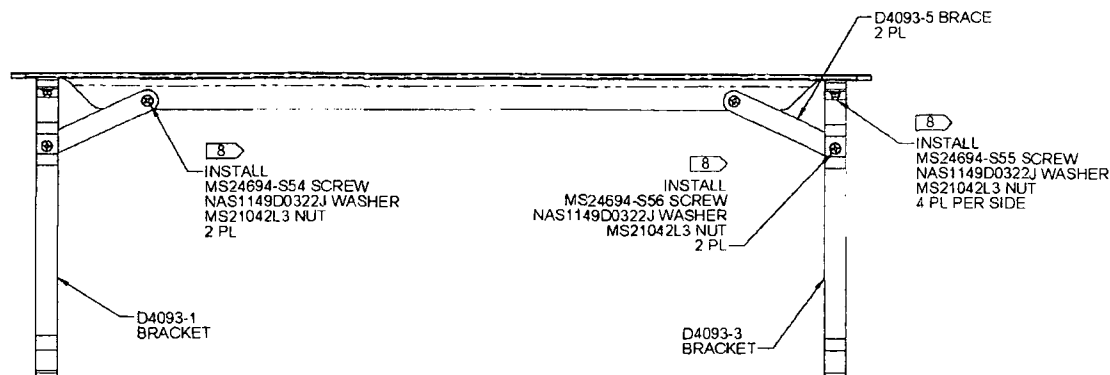
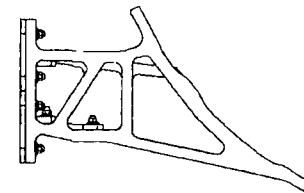
10.10.04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 6.01 lbs
 - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
 - 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4092	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y	NTS
DATE	10.10.04	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	



D4092-1
MAINTENANCE STEP



8
INSTALL
MS24694-S54 SCREW
NAS1149D0322J WASHER
MS21042L3 NUT
2 PL

8
INSTALL
MS24694-S56 SCREW
NAS1149D0322J WASHER
MS21042L3 NUT
2 PL

8
INSTALL
MS24694-S55 SCREW
NAS1149D0322J WASHER
MS21042L3 NUT
4 PL PER SIDE

D4093-1
BRACKET

D4093-3
BRACKET

w/o 63047

D4092-042 MAINTENANCE STEP ASS'Y

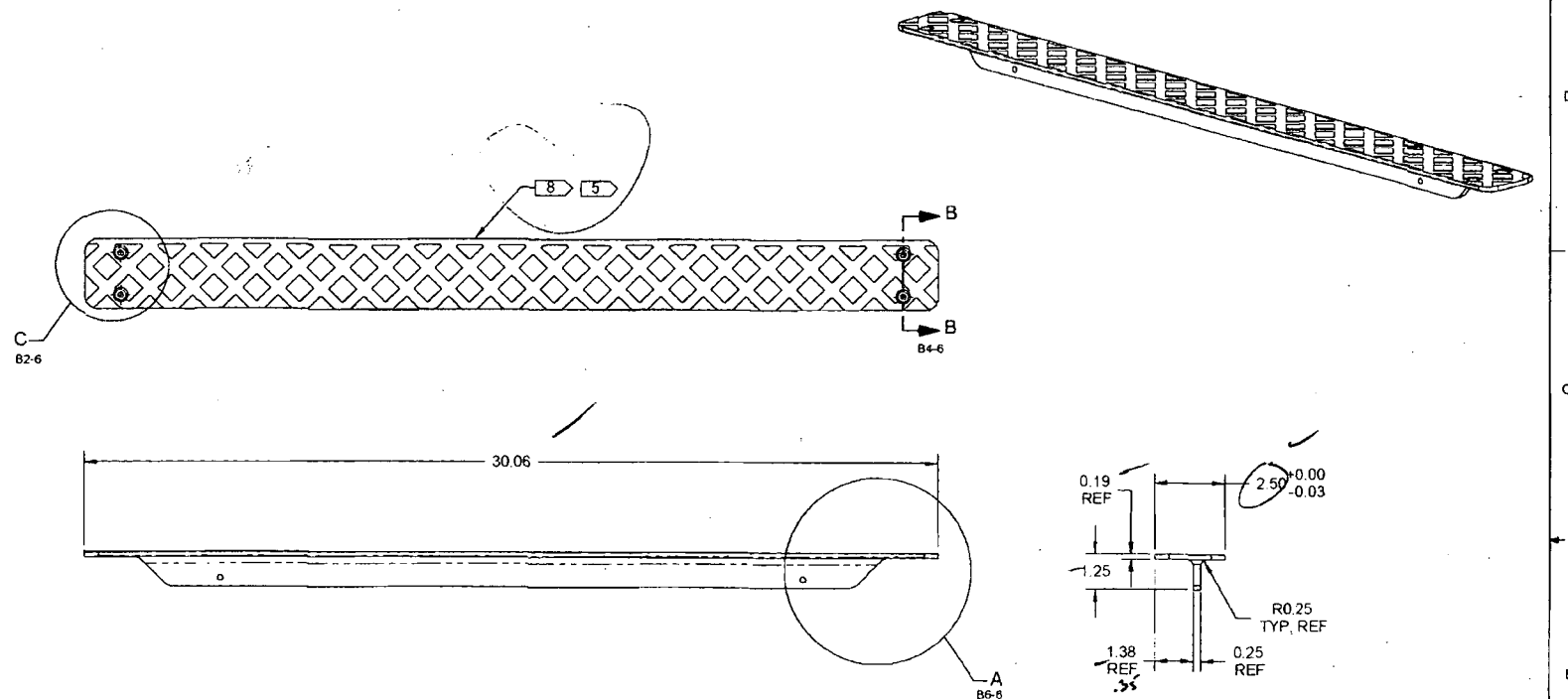
PRELIMINARY ISSUE

10.10.04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.99 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D4092	REV. PB1
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE MAINTENANCE STEP ASS'Y	SCALE NTS
DATE	10.10.04	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION OF THE REFERENCE ORIGIN THAT IS NOT TO BE USED FOR REPRODUCTION OR DISSEMINATION TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.	



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

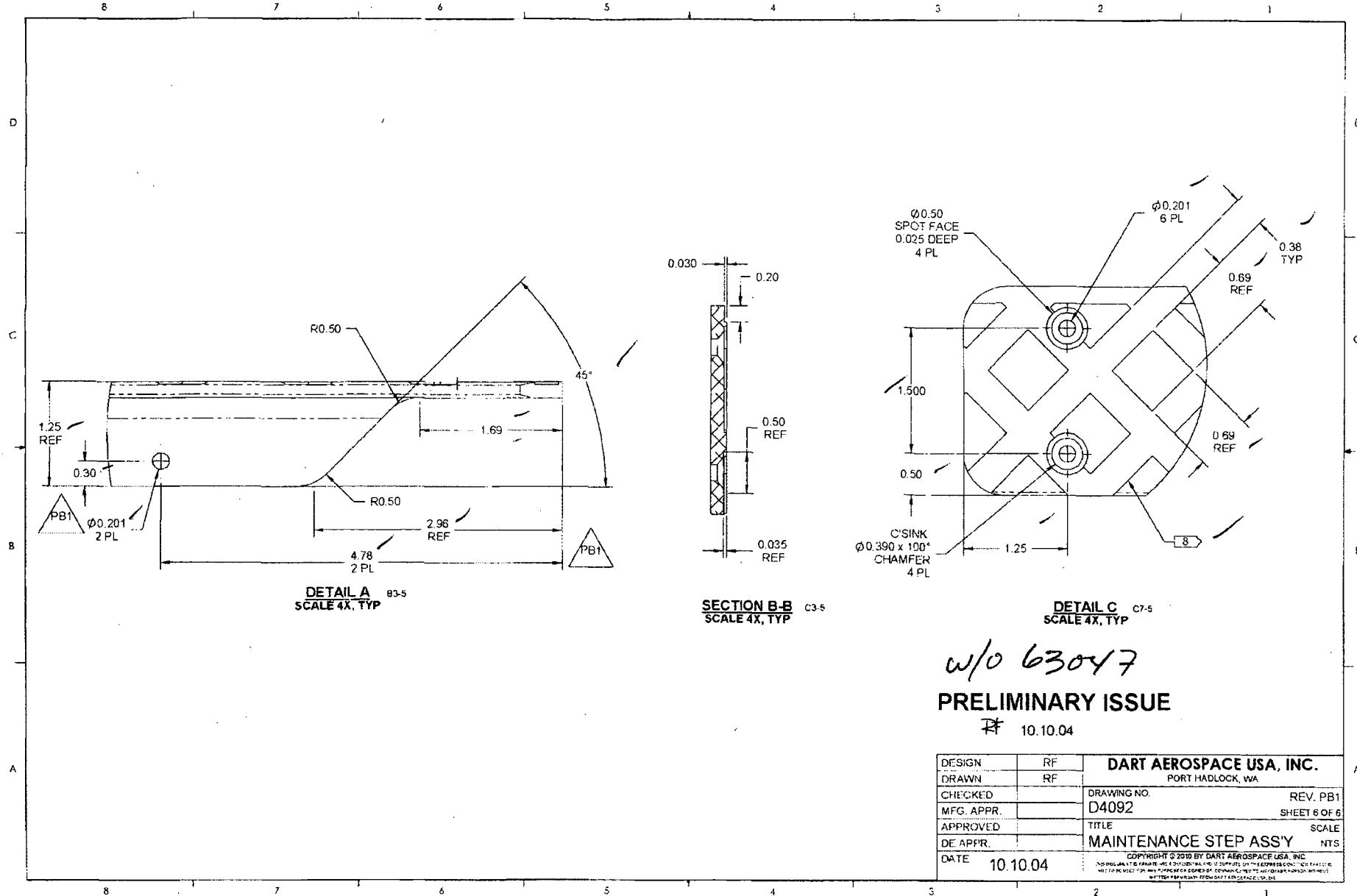
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK SPOT FACE HOLES PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

PRELIMINARY ISSUE

10.10.04

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4092	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y	NTS
DATE	10.10.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

w/063047



DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4092	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y	NTS
DATE	10.10.04	<small> COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. NO REPRODUCTION OR TRANSMISSION IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. </small>	

DART AEROSPACE LTD	Work Order :	B8323
Description: Extrusion	Part Number:	D2761
Dwg: D2761 Rev. A	Qty:	27

Step	Location	Procedure	By	Date
1	EXPEDITING	OPEN W/O	CS	98.10.08
2	PURCHASING	Issue P/O: <u>2000966</u> a) Extrude as per Dwg D2761 b) Material: 6061-T6 (QQ-A-200/8) c) Tool: MS-19021 d) Material certification is required	Ky	98.10.08
3	QC	Inspect for freight damage and check test report is attached	DM	98.11.19
4	QC	Inspect Level 6 Check Test Report to Dwg D2761 for compliance	DM	98.11.19
5	STORES	Tag and stock.	DM	98.11.19
6	EXPEDITING	CLOSE W/O ✓ Cost / Job <u>23.25</u>	CS	98.11.26

Rev	Date	Change	Created By	Approved
A	98.05.08	New Issue	CS	CS

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Shepherd
Inspector

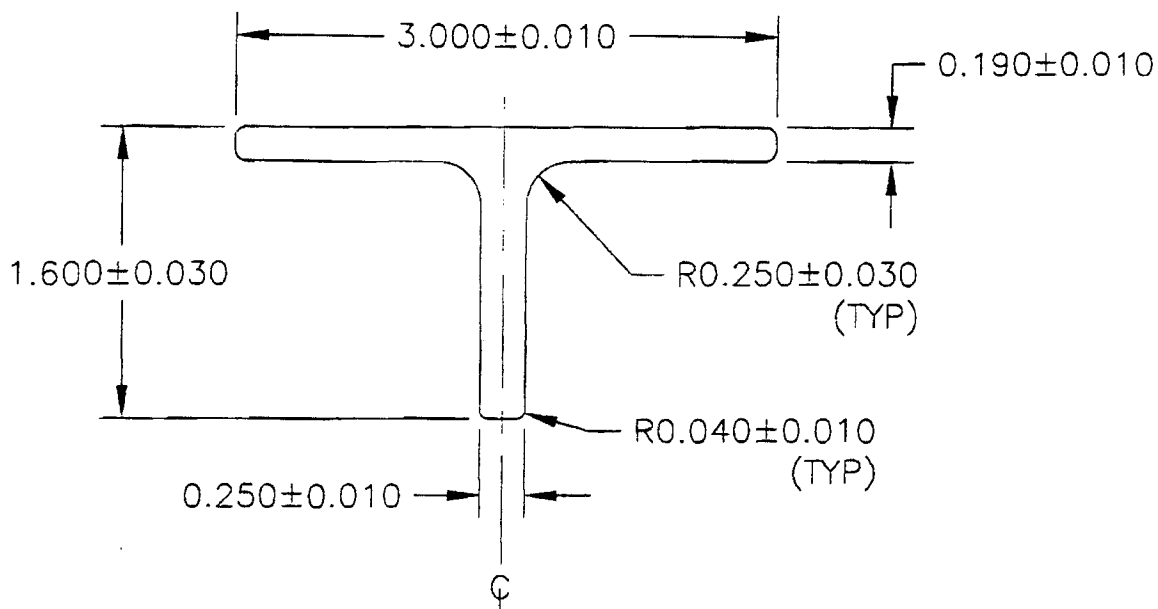
Date 98.11.26 Authorized



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MOY</i>	APPROVED <i>AS</i>	DRAWING NO. D2761	REV: A SHEET 1 OF 1
DATE 98.03.16		TITLE EXTRUSION	SCALE 1:1
A	98.03.16	NEW ISSUE	

RELEASED
95104/03 KE

WORK ORDER
NO. B8323



MATERIAL: 6061-T6 (QQ-A-200/8).

NO TOOLING ID MARK.

EXTRUSION IS SYMMETRIC ABOUT CL.

**SHOP COPY
RETURN TO
ENGINEERING**

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**
Adresse / Address : **1270 ABERDEEN STREET
HAWKESBURY ONT, K6A 1K7**

commande Indalex / Indalex order # : **8101485**
bon de commande / Purchase order # : **2000966**
de matrice / Die # : **MS 19021** Description : **HELICOPTER RAFTERS**
Alliage & trempage / Alloy & temper : **6061 T-6**
de coulée / Cast # : **19557**
de contrôle / Control # : **3398-1**

Composition chimique typique / Typical chemical composition :

Si:0.72-0.76/ Fe:0.20-29/ Cu:0.24-0.28/ Mn:0. 0.06-0.10/ Mg:0.84-0.88/ Cr:0.05-0.09/ Zn:0.08max /Ti:0.04max

Dureté Rockwell E / Rockwell E Hardness : **92 HRE**

	Min.requis Min.required	Résultat actuel Actual results
Contrainte élastique Yield stress (psi)	35 000	36 447
Tension ultime Ultimate stress (psi)	38 000	42 812
% élongation dans 2" % elongation in 2"	8	16

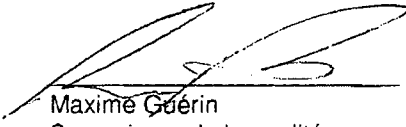
**** Rupture hors de la moitié du milieu de la section de mesure / Broke outside of the middle half of the gauge length**

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par l'Association de l'Aluminium ainsi que les exigences de nos procédures de contrôle de qualité.

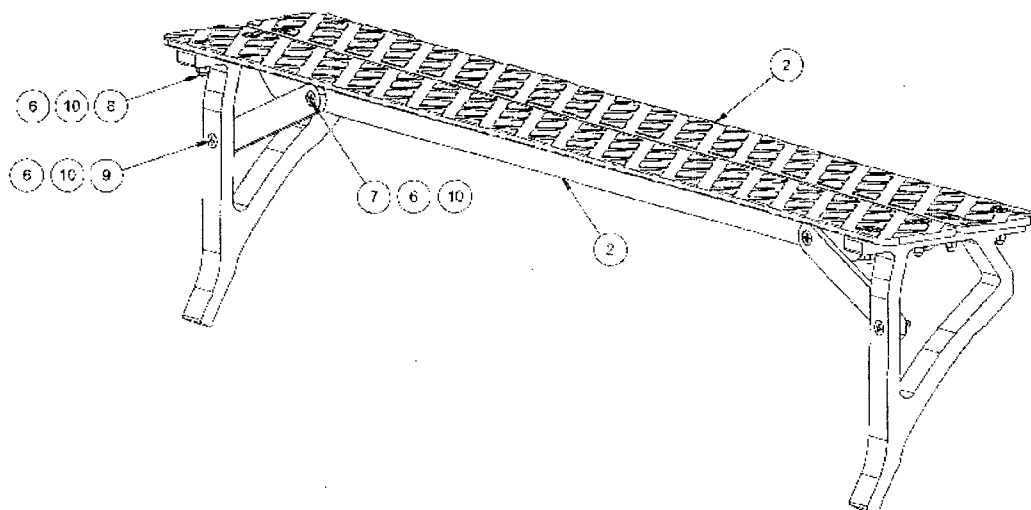
We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : **98/11/04**


Maxime Guérin
Superviseur de la qualité
Quality supervisor

CARADON INDALEX, Div.de Caradon Ltée



D4092-041 MAINTENANCE STEP ASSEMBLY

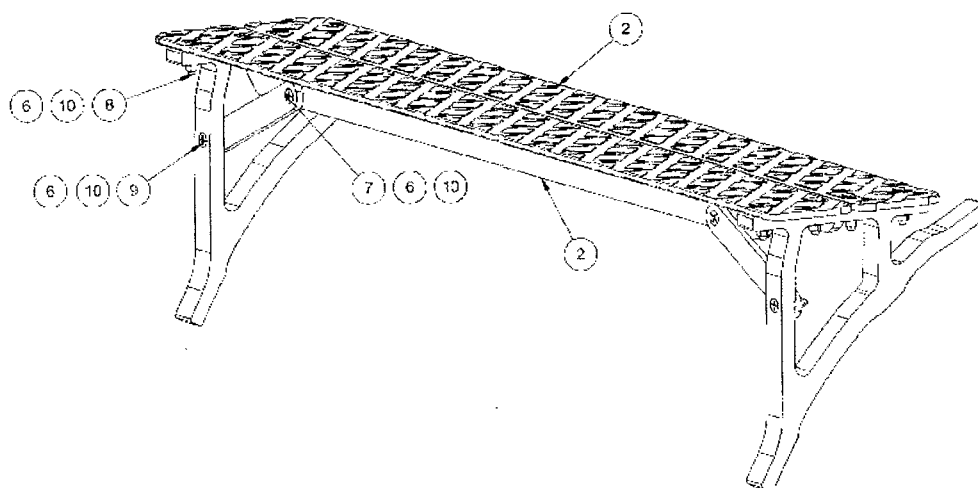


ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

RELEASED
2011-09-22
JW

B	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KFNT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

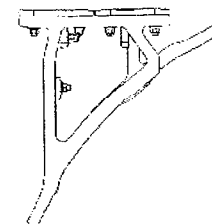
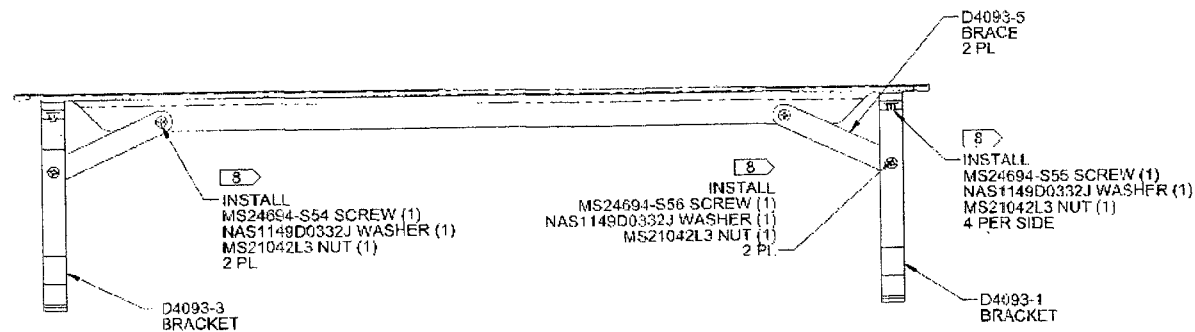
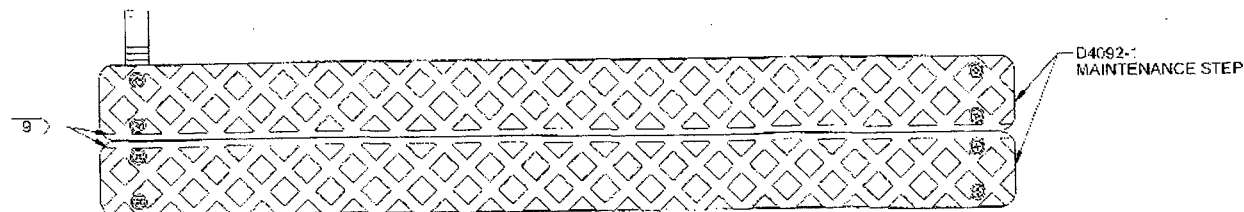


D4092-042 MAINTENANCE STEP ASSEMBLY



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2011-09-20
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y NTS	
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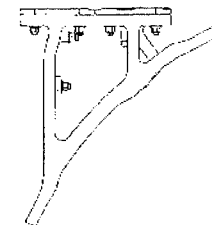
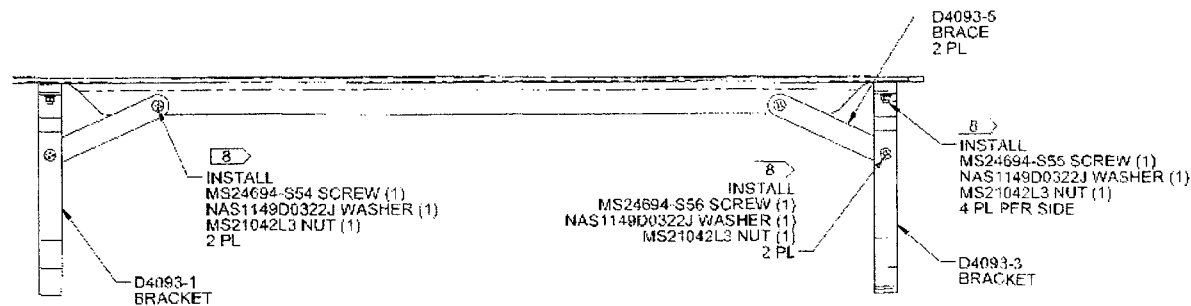
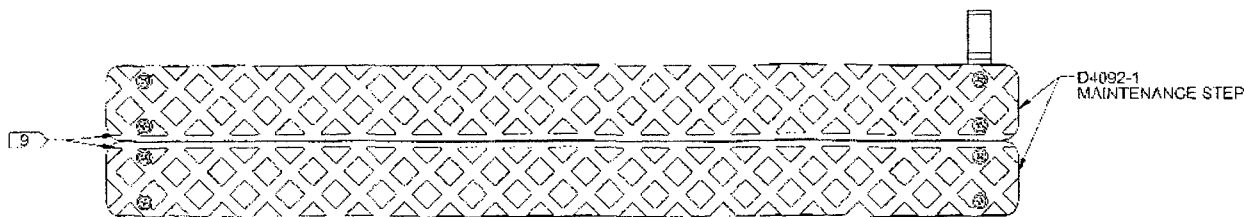
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	
DATE	11.07.27	N'S	

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2011-09-22



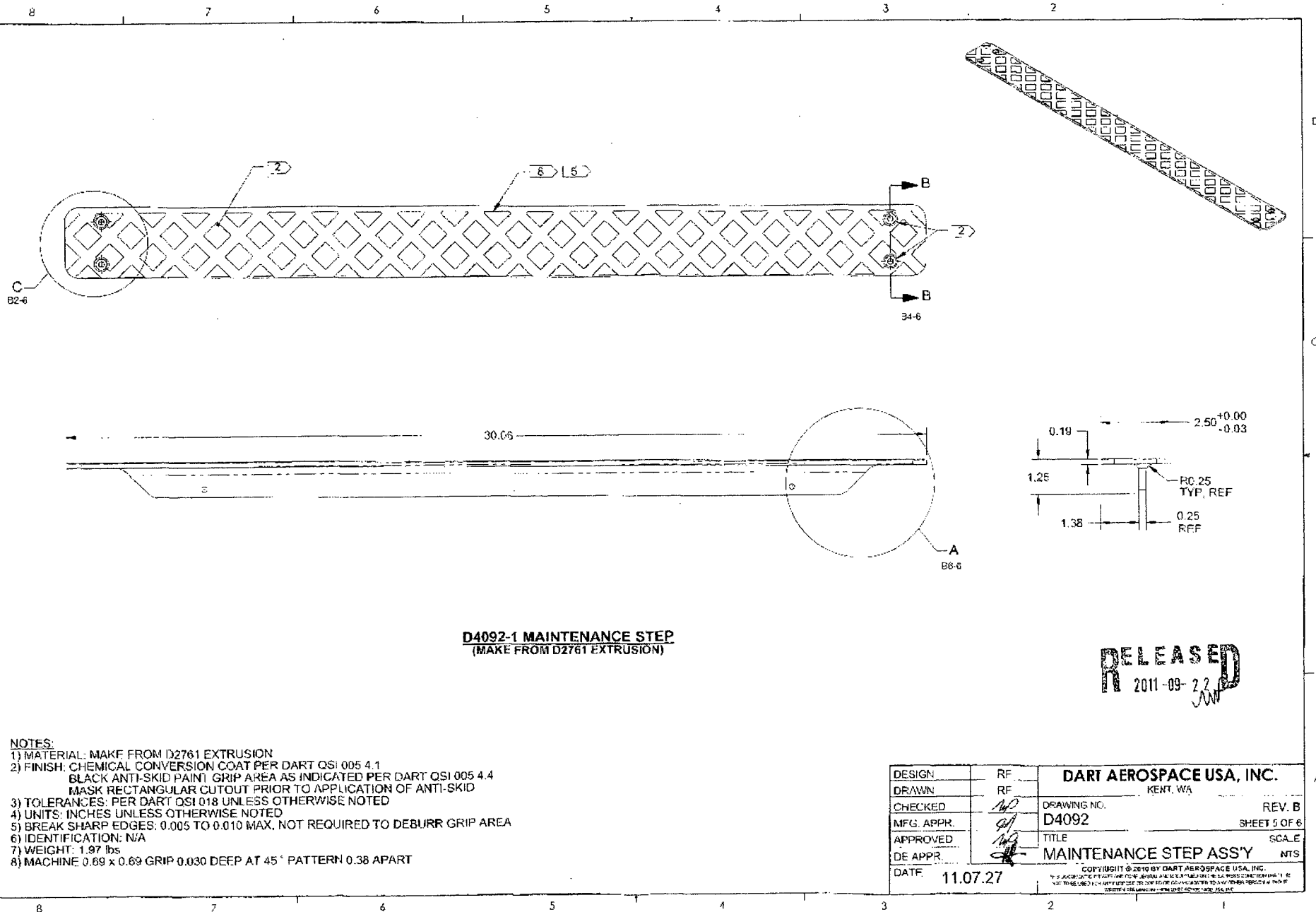
D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER OSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D4092	SHEET 4 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	MAINTENANCE STEP ASS'Y NTS	
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2011-09-22



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART OSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE: 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	NTS
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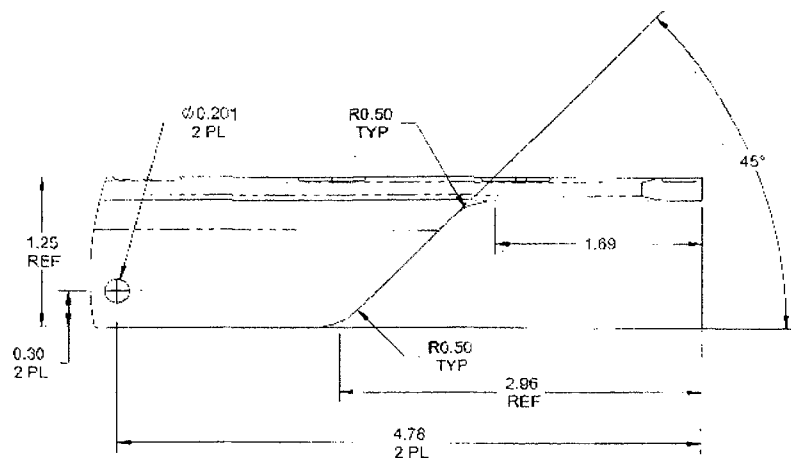
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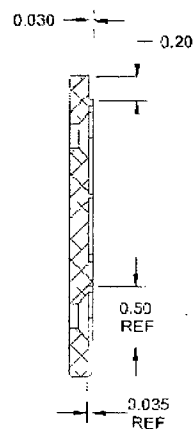
C

B

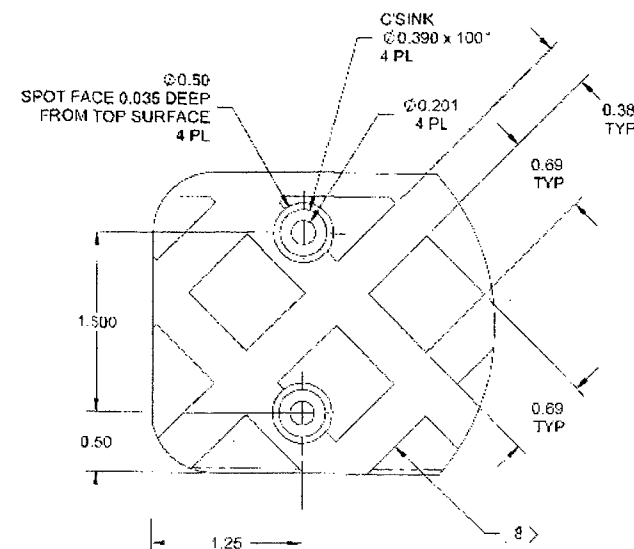
A



DETAIL A
SCALE 3X, TYP



SECTION B-B
SCALE 3X, TYP



DETAIL C
SCALE 3X, TYP

RELEASED
2011-09-22
AM

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 5 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	

A

B

C

D

8 7 6 5 4 3 2 1

17189

Work Order ID, 62564



PRELIMINARY ISSUE

Page 1

Monday, October 04, 2010 1:10:59 PM

Item ID: D4092-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Maintenance Step

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:



Required Date: 10/18/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: mfDate: 10-10-04

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4092

100



Bandsaw

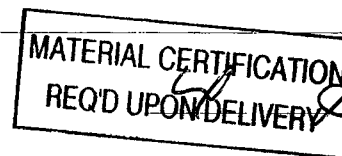
Jeaspa Bandsaw

Cut blanks as per folio

0.00

Memo

0.00

SA 10/10/01

110



HAAS I

HAAS CNC vertical machine #1

Memo

0.00

0.00

Mill as per Dwg and Folio FA935

Dwg Rev:

Folio rev:

Deburr

SA 10/11/014 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 62564

Monday, October 04, 2010 1:10:59 PM

Page 2

Item ID:	D4092-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Maintenance Step					
Start Date:	10/5/2010	Start Qty:	4.00	Cust Item ID:		
Required Date:	10/18/2010	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		
QC Quality Control	Memo SN 10/11/01	0.00							
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo - inspecto Parts to PB1 Dy only 8/10/11/00 (x4)	0.00							
140 	Chemical Conversion Coat per QSI005 4.1	0.00				4	0		
HandFinish Hand Finishing	Memo 2/11/10 10/11/01	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 62564




Monday, October 04, 2010 1:10:59 PM



Page 3

Item ID: D4092-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Maintenance Step
Start Date: 10/5/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 10/18/2010 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115791 START. 1:30</i> Memo <i>QWENT. 320°</i> <i>FINISH. 2:00.</i>	0.00 0.00				<i>4</i>	<i>10-11-2</i>		
155  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115790</i> Memo	0.00	<i>JH</i>	<i>10/11/03</i>		<i>4</i>	<i>0</i>		
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62564

Monday, October 04, 2010 1:10:59 PM

Page 4

Item ID: D4092-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Maintenance Step

Start Date: 10/5/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 10/10/2010 AUTH U

RELEASED _____ DATE _____

MF
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, October 04, 2010 1:10:59 PM

Work Order ID: 62564



Parent Item: D4092-1



Parent Item Name: Maintenance Step

Start Date: 10/5/2010

Required Date: 10/18/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: lpp Rev:A New Issue 10-05-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108		Manufactured	No			100	f	221.5800	0.333333333	1.403509			



Extrusion (HPK)

Location

Loc Qty

Loc Code

MAT07

221.58

8323

221.58

10.1 Rt SA 10/10/10

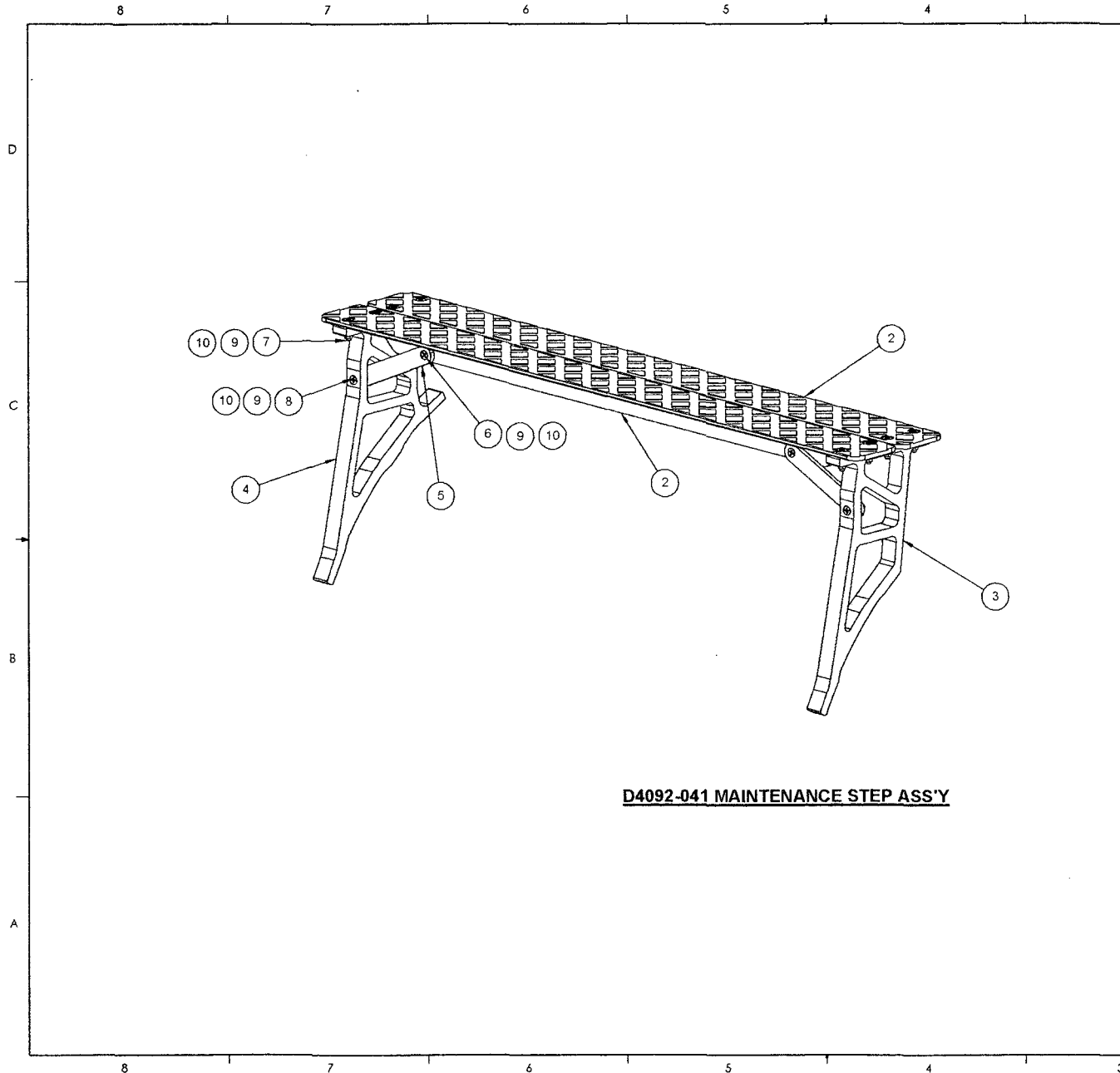
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASS'Y
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT

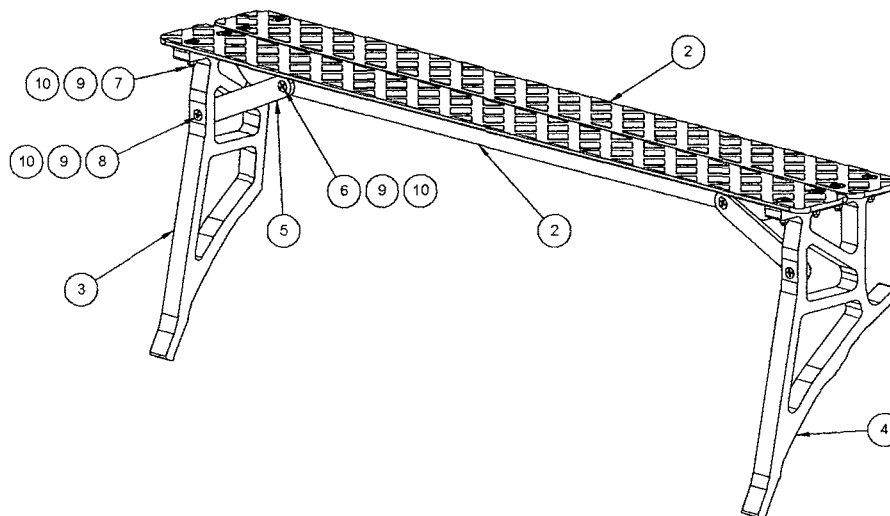
w/o 62564

D4092-041 MAINTENANCE STEP ASS'Y

PRELIMINARY ISSUE

10.10.04

PB1	ADD DIMENSIONS (ZN B8-6 & B5-6)	RF	10.10.04
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4092	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y	NTS
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ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASS'Y
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	2	MS24694-S54	SCREW
7	8	MS24694-S55	SCREW
8	2	MS24694-S56	SCREW
9	12	NAS1149D0332J	WASHER
10	12	MS21042L3	NUT

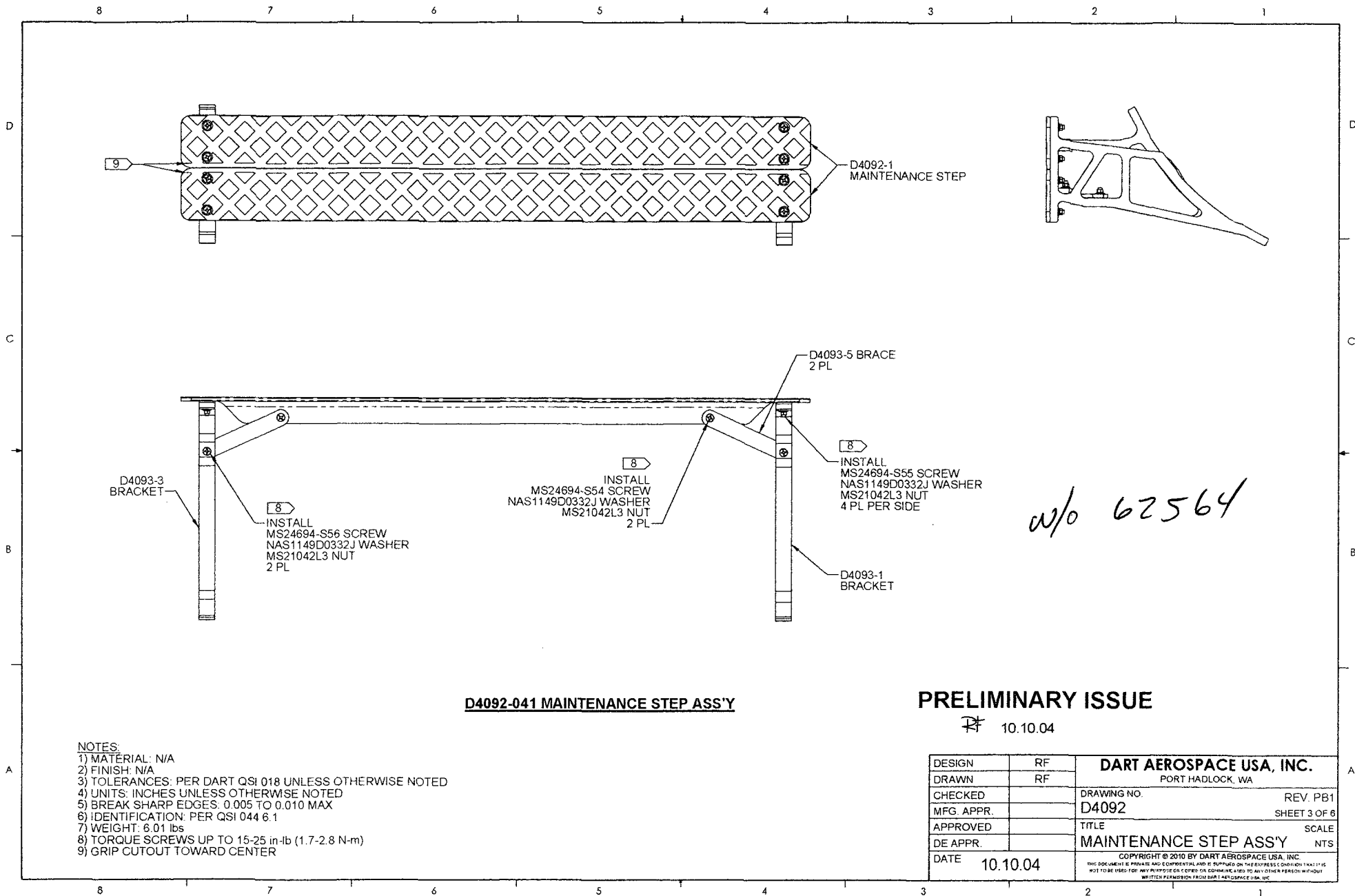
w/o 67564

D4092-042 MAINTENANCE STEP ASS'Y

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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 6.01 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

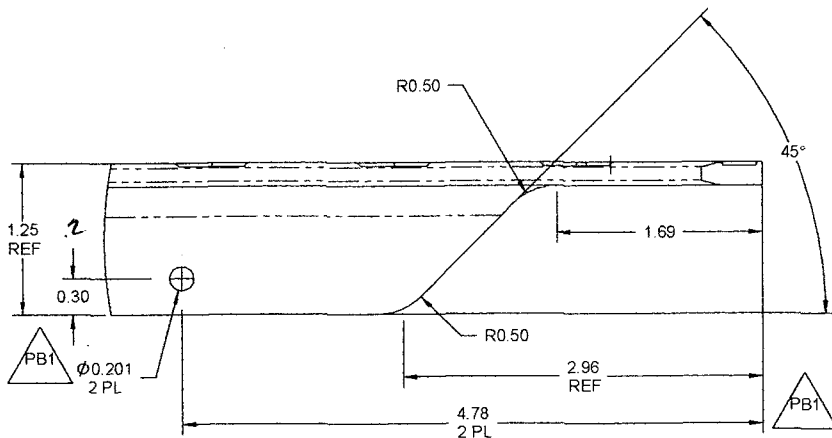
- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK SPOT FACE HOLES PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

PRELIMINARY ISSUE

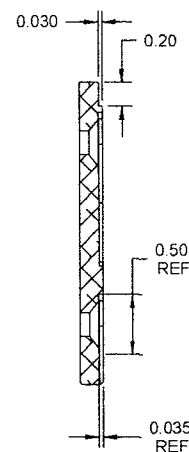
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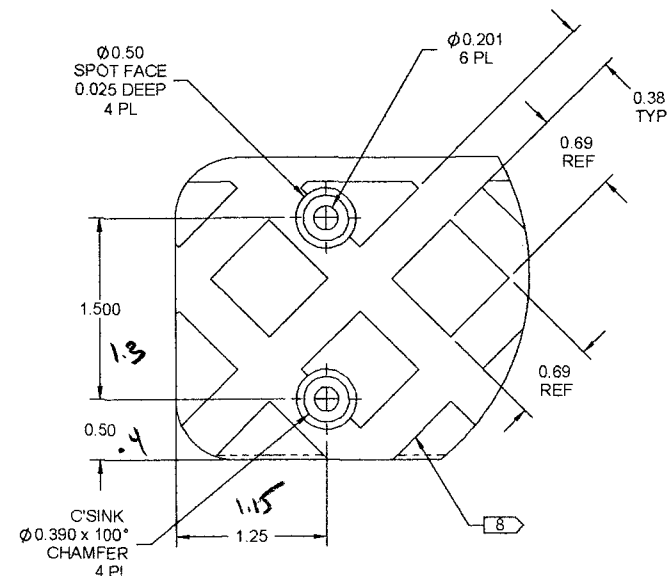
w/o 62564



DETAIL A B3-5
SCALE 4X, TYP



SECTION B-B C3-5
SCALE 4X, TYP



DETAIL C C7-5
SCALE 4X, TYP

w/o 67564

PRELIMINARY ISSUE

10.10.04

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